

Work Order ID 53421

November 04, 2009 9:18:16 AM



Page 1

Item ID: D2917-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle LH

Start Date: 11/5/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 11/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 09-11-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2917	Rev B

100



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

MF / 88 09/11/14

HAAS CNC vertical machine #1

Program batch number□Machine Step No 1 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet□Machine Step No 2 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet□Machine Step No 3 as per Folio

110



CONVENTIONAL MILLING MACHINE

0.00

88 69/11/14

Mill Conv

Conventional Milling Machine

Memo

0.00

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

120



QC2- Inspect parts off machine FAI/FAIB

0.00

88 09/11/14

QC

Quality Control

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53421

November 04, 2009 9:18:16 AM



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Item ID: D2917-1

Revision ID: B

Item Name: Saddle LH

Start Date: 11/5/2009 Start Qty: 10.00

Required Date: 11/11/2009 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____

Date: _____

QC: _____

Date: _____

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Tooling: _____

SPC (Y/N): _____

Set Up/
Run Hours

0.00

Draw
Number

11.19

Draw
Rev.

10

Plan
Code

10

Accept
Qty

10

Reject
Qty

10

Reject
Number

10

Insp.
Stamp

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

10/14/19

X(10)

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

10/11/20

X(10)

10/11/20

M12140
START TIME: 9:20AM FINISH TIME: 9:50AM OVEN TEMPERATURE: 370°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53421

November 04, 2009 9:18:16 AM



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Item ID: D2917-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle LH

Start Date: 11/5/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 11/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Memo

Set Up/
Run Hours

0.00

0.00

Draw
Number

09-11-20

Draw
Rev.Plan
CodeAccept
Qty

10

Reject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/09/11 20 10**10/09/11 23**10/09/11/20 10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 04, 2009 9:18:15 AM

Page 1

Work Order ID: 53421



Parent Item: D2917-1RevB



Parent Item Name: Saddle LH

Start Date: 11/5/2009

Required Date: 11/11/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-010RevD		Manufactured	No			100	Each	11.0000	10.0000			

Saddle Billet

Location

Main Warehouse

MATH

51423

11

Loc Code

5

mf 09/12/13

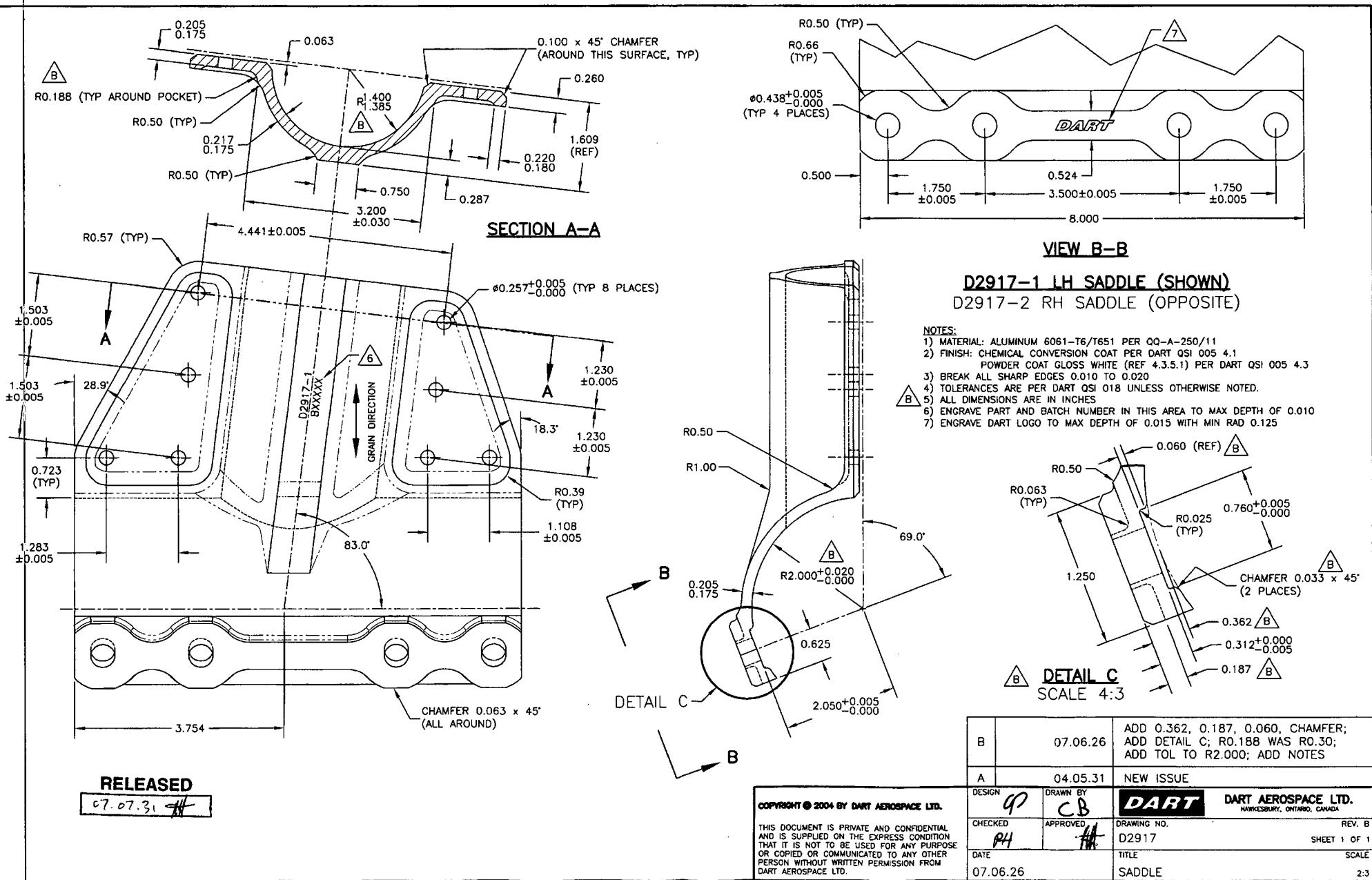
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	53421
Description: Saddle LH				Part Number:	D2917-1
Inspection Dwg: D2917 Rev. A1				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.175	0.205		.195	.189	.188	.188		
B	0.090	0.110		.090		.090	.090		
C	0.250	0.270		.265	.265	.265	.265		
D	1.599	1.619		1.615	1.614	1.615	1.615		
E	0.180	0.220		.180	.180	.191	.190		
F	0.277	0.297		.286	.290	.290	.286		
G	1.385	1.400		1.388	1.387	1.387	1.386		
H	3.170	3.230		3.200	3.206	3.206	3.206		
I	0.175	0.217		.180	.189	.191	.191		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.502	1.502	1.502	1.502		
L	4.436	4.446		4.441	4.441	4.441	4.441		
M	0.257	0.262	DT8683	.260	.260	.260	.260		
N	1.225	1.235		1.230	1.230	1.230	1.230		
O	1.103	1.113		1.107	1.107	1.107	1.107		
P	0.470	0.530		.499	.500	.500	.500		
Q	0.438	0.443	DT8682	.442	.443	.443	.443		
R	0.490	0.510		.499	.501	.502	.500		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.001	8.000	8.000	8.000		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.205	.205	.205	.205		
W	1.990	2.010		2.000	2.000	2.000	2.001		
X	0.760	0.765		.763	.763	.763	.763		
Y	0.307	0.312		.312	.312	.312	.310		
Z	0.615	0.635		.623	.623	.623	.623		
AA	0.177	0.197		.186	.188	.187	.187		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>SL</i>	Audited by:	<i>SL</i>
Date:	<i>09/11/18</i>	Date:	<i>09. 01. 19</i>

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM <i>SL</i>	<i>SL</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order: 5342
Description: Saddle LH			Part Number: D2917-1
Inspection Dwg: D2917 Rev. A1 17			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 X	6 8	7 8	8 4	By	Date
A	0.175	0.205		.190	.188	.183	.188		
B	0.090	0.110		.090	.090	.090	.090		
C	0.250	0.270		.265	.265	.265	.265		
D	1.599	1.619		1.610	1.610	1.610	1.615		
E	0.180	0.220		.190	.190	.190	.190		
F	0.277	0.297		.291	.290	.290	.286		
G	1.385	1.400		1.394	1.390	1.390	1.393		
H	3.170	3.230		3.206	3.209	3.209	3.209		
I	0.175	0.217		.190	.190	.191	.188		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.502	1.502	1.502	1.502		
L	4.436	4.446		4.441	4.441	4.441	4.441		
M	0.257	0.262	DT8683	.260	.260	.260	.260		
N	1.225	1.235		1.230	1.230	1.230	1.230		
O	1.103	1.113		1.107	1.107	1.107	1.107		
P	0.470	0.530		.500	.500	.500	.500		
Q	0.438	0.443	DT8682	.443	.443	.443	.443		
R	0.490	0.510		.502	.500	.502	.500		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.000	8.000	8.000	8.000		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.201	.200	.205	.200		
W	1.990	2.010		2.008	2.003	2.000	2.008		
X	0.760	0.765		.760	.760	.760	.760		
Y	0.307	0.312		.310	.310	.310	.310		
Z	0.615	0.635		.625	.625	.625	.625		
AA	0.177	0.197		.187	.188	.186	.187		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	8P	Audited by:	ad
Date:	09/11/13	Date:	09. 11. 14

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	ad

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53421
Description: Saddle LH	Part Number:	D2917-1
Inspection Dwg: D2917 Rev. A1 (DU)		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				7X	102	3	4		
A	0.175	0.205		.184	.189				
B	0.090	0.110		.090	.090				
C	0.250	0.270		.261	.261				
D	1.599	1.619		1.615	1.615				
E	0.180	0.220		.130	.130				
F	0.277	0.297		.291	.291				
G	1.385	1.400		1.390	1.390				
H	3.170	3.230		3.209	3.210				
I	0.175	0.217		.280	.280				
J	0.470	0.530		.500	.500				
K	1.498	1.508		1.502	1.502				
L	4.436	4.446		4.441	4.441				
M	0.257	0.262	DT8683	.260	.260				
N	1.225	1.235		1.230	1.230				
O	1.103	1.113		1.107	1.107				
P	0.470	0.530		.500	.500				
Q	0.438	0.443	DT8682	.443	.443				
R	0.490	0.510		.500	.500				
S	1.745	1.755		1.750	1.750				
T	7.990	8.010		8.020	8.000				
U	3.495	3.505		3.500	3.500				
V	0.175	0.205		.200	.200				
W	1.990	2.010		2.000	2.008				
X	0.760	0.765		.760	.760				
Y	0.307	0.312		.310	.310				
Z	0.615	0.635		.625	.625				
AA	0.177	0.197		.183	.183				
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>845</i>	Audited by:	<i>ml</i>
Date:	<i>09/11/14</i>	Date:	<i>09-11-14</i>

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM <i>ml</i>	<i>ml</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries